



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada
Tel (613) 632-5200

*European
warehouse*



646.4002
Job Sheet 178338

Part No: 646.4002

Job Qty: 1 ea

Part Name: AS350 Wiper Deflector



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 5/30/18

Job Tracking No:

Due Date: 6/1/18

Created By: Linda Lacelle

Type: Stock

Description:

Note: DWG REV C1 IPP REV:A 12.12.23 NEW ISSUE DD VERF:JLM IPP REV:B 16.01.07 DWG REV:C DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard	Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier Lead Time	
90	Start up Operation	1 Ea	6/1/18	6/1/18	0.00	0.00	Start Up Stores/Pkg-1	<i>9-80</i> JUN 01 2018
110	Packaging	1 pcs	6/1/18	6/1/18	0.00	0.00	Packaging1-1	<i>9-80</i> JUN 01 2018
120	QC	1 pcs	6/1/18	6/1/18	0.00	0.00	QC4	<i>9-80</i> JUN 01 2018
130	Packaging	1 pcs	6/1/18	6/1/18	0.00	0.00	Packaging3-1	<i>9-80</i> JUN 01 2018
135	DC	1 pcs	6/1/18	6/1/18	0.00	0.00	DC	<i>9-80</i> JUN 01 2018
140	QC21-FG	1 Ea	6/1/18	6/1/18	0.00	0.00	QC21	<i>9-80</i> JUN 01 2018

Part Op 130 - Identify and pack for shipping as per PPP 646.4002 Location : FG102
Descriptions: 135 - Photocopy bluefile & type labels per PPP 646.4002

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
600.1012	Sealant PR1425B2 (#654 sem)	1 pcs (1 ea)	90-Start up Operation	
646.3410	LH Wiper Deflector	1 Ea (1 ea)	90-Start up Operation	
646.3411	RH Wiper Deflector	1 Ea (1 ea)	90-Start up Operation	
646.3814	Wiper Bracket	2 Ea (2 ea)	90-Start up Operation	
MS21042L3	Nut	6 Ea (6 ea)	90-Start up Operation	
MS24694-S53	Screw	2 Ea (2 ea)	90-Start up Operation	
MS27039-1-18	Screw	2 Ea (2 ea)	90-Start up Operation	
MS27039-1-19	Screw	2 Ea (2 ea)	90-Start up Operation	
NAS1149F0332P	Washer	16 Ea (16 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	600.1012	1	23	0
	646.3410	1	8	0
	646.3411	1	8	0
	646.3814	2	20	0
	MS21042L3	6	1,589	0
	MS24694-S53	2	229	0
	MS27039-1-18	2	1,321	0
	MS27039-1-19	2	415	0
	NAS1149F0332P	16	2,392	0

3595



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CANADA
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Container No: S077086



Part: 646.4002

Job No: 178338

Serial No/Batch: S077086

Revision:

Inspector:

Exp Date:

Instructions:

06/01/2018

Date: 06/01/18

Part Specifications
Specifications could not be found.

Plex 5/30/18 8:56 AM dart.lacelle.linda



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Container View (Active) - Master Unit Containers

Master Unit No	Container No	Part No	Part Name	From Container	Current Location	Quantity
01/19 003595	S077061	600.1012	Sealant PR1425B2 (#654 sem)	S075327	CCK017	1
003595	S077062	646.3410	LH Wiper Deflector	F125082-10	CCK010	1
003595	S077063	646.3411	RH Wiper Deflector	S032533	CCK010	1
003595	S077064	MS21042L3	Nut	S075328	ST303	6
003595	S077065	MS24694-S53	Screw	F113359	ST284	2
003595	S077066	MS27039-1-18	Screw	F124326	OVER006	2
003595	S077068	MS27039-1-19	Screw	S065263	ST280	2
003595	S077069	NAS1149F0332P	Washer	S068663	ST262	16

Note: Ad hoc query view of Part.dbo.Container where Container.Active = 1.

Plex 6/1/18 9:29 AM dart.quirion.sonia

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NOTES:

1 AFTER INSTALLATION, APPLY F/N 54 A/R TO FILL GAPS AND FILLET EDGES.

2 INSTALL F/N 14 WITH F/N 52 & 53.

3 3M VHB ADHESIVE TAPE .025" THICK X .50" WIDE
VENDOR: MCMASTER-CARR P/N 75935A651.

4 3M TAPE PRIMER 94, APPLY TO BOTH SURFACES A/R BEFORE TAPE.
VENDOR: R.S. HUGHES P/N 021200-24216.

5 REUSE FASTENERS FROM F/N 1.

6 USE WASHERS A/R AS SHIMS TO OBTAIN BEST FITMENT.

7 AT CUSTOMERS OPTION, INSTALL F/N 65 BY MATCH DRILLING ON TO F/N 1.

8 INSTALL SHIM IF OEM PROVISIONS ARE INSTALLED ON AIRCRAFT, REMOVE
SHIM LAYERS TO ACHIEVE CORRECT SIZE. MATCH DRILL HOLES. USE F/N 78
SCREW IN PLACE OF F/N 17 SCREW.

9 NEWER INSTALLATIONS ON AIRCRAFT WITH UPDATED CANOPY MAY
REQUIRE DIFFERENT LENGTH SCREWS. USE F/N 62 TO REPLACE F/N 44 &
F/N 26 IN PLACE OF F/N 41 WHEN NECESSARY.

UNINCORPORATED ECN(S)

05304

5	5	5	78	601.3875	SCREW	UNINCORPORATED				
1	1	1	77	646.9410	SHIM					
	4	4	76	601.2764	WASHER	MS11490000				
	2	2	75	601.2973	LOCKNUT	MS21042-08				
	2	2	74	601.2988	SCREW	MS27039-081-3				
	2	2	73	601.2943	LOCKNUT	MS21042-3				
	2	2	72	601.3128	NUT	AN316C4R				
	2	2	71	601.3209	LOCKNUT	MS21042-4				
	4	4	70	601.2638	WASHER	UNAS11490000				
	2	2	69	601.2669	BOLT	ANAC7A				
	2	2	68	601.3119	CLEVIS	AN665-34R				
	2	2	67	601.3121	EYE BOLT	AN66-5A				
	2	2	66	650.9201	EYE BRACKET ASSY					
REF	REF	REF	65	647.5701	GPS MOUNT KIT					
		2	64	601.3151	WASHER	UNAS11490000				
			63	601.2911	SCREW	MS26474553				
	24	24	62	601.2637	SCREW	MS27039-1-16				
2	2	2	61	601.2763	BOLT	AN3-12A				
	1	1	60	646.3913	SHIM					
	4	4	59	646.3912	SHIM					
	1	1	58	646.3911	SHIM					
	4	4	57	646.3910	SHIM					
	5	5	56	600.1013	PRIMER					
8 FT		8 FT	55	600.0129	VHB TAPE					
1		1	54	600.1012	SEALANT	PR-1425 CLASS B				
	1	1	53	600.0991	MAGNABOND 6398 PART B					
	1	1	52	600.0990	MAGNABOND 6398 PART A					
6	10	10	51	601.2826	BOLT	AN3-11A				
		2	50	646.3814	WIPER BRACKET					
		2	49	601.2910	SCREW	MS27039-1-18				
	2	2	48	601.1365	SCREW	MS27039-1-10				
	2	2	47	646.3719	DOUBLER					
	2	2	46	646.3718	CUSTOM WASHER					
	1	1	45	646.3717	DOUBLER					
	22	22	44	601.1948	SCREW	MS27039-1-19				
	2	2	43	601.1952	SCREW	MS27039-1-20				
	4	4	42	601.1956	SCREW	MS27039-1-21				
4006	4005	4004	4003	4002	4001	FIND #	PART #	DESCRIPTION	MATL	SPEC.

REV	DESCRIPTION	DATE	APPROVED
A	INCORPORATED ECN 02199, 02201, 02174 & 02175	03/08/2010	P. BRAVO
B	INCORPORATED CHG 03041, 03079 & 04131	11/04/2014	P. BRAVO
C	INCORPORATED ECN 03098	04/01/2015	P. BRAVO

		2	2	41	601.2829	SCREW	MS20494554			
		2	2	40	601.2831	RIVET	MS20476ADS-7			
		1	1	39	646.3716	GAUGE BRACKET				
		6	6	38	601.1953	SCREW	MS27039-1-12			
	2		2	37	646.3715	STRUT DOUBLER				
		2	2	36	601.2824	BOLT	AN3-5A			
12	36		36	35	601.2277	RIVET	CCR6466-3-00			
6	18		18	34	600.0795	NUTPLATE	MS21047-3			
3	3		3	33	601.2565	RIVET	MS20476ADS-7			
1	1		1	32	646.3813	STRUT BRACKET				
4	4		4	31	601.2822	BOLT	AN3-3A			
2	2		2	30	646.3812	GUSSET BRACKET				
8	8		8	29	601.2564	RIVET	MS20476ADS-6			
1	1		1	28	646.3714	GUSSET				
	1	1	1	27	646.3610	FILLER				
	3	3	3	26	601.2830	SCREW	MS20469AS55			
	2	2	2	25	601.2825	BOLT	AN3-6A			
	1	1	1	24	646.3811	RADIUS BLOCK				
	1	1	1	23	646.3712	CLIP				
	1	1	1	22	646.3711	CLIP				
8	8		8	21	601.2832	RIVET	MS20476ADS-5			
14	14		14	20	601.2020	RIVET	CR3213-5-3			
4	6	4	6	10	19	601.2823	BOLT	AN3-4A		
	1	1	1	18	601.2827	BOLT	AN3-13A			
	5	5	5	17	601.2912	SCREW	MS20469AS51			
1	1		1	16	646.3713	GUSSET				
1	1		1	15	646.3210	SUPPORT				
		1	1	14	646.3710	DOUBLER				
		1	1	13	646.3110	CHANNEL				
14	10	8	53	61	12	601.1624	LOCKNUT	MS210421-3		
16	32	18	120	16	144	11	601.1607	WASHER	NAS1149F0303P	
					10	646.3410	LH WIPER DEFLECTOR			
					9	646.3411	RH WIPER DEFLECTOR			
			2	2	8	647.7703	STRUT ASSY			
			2	2	7	647.0112	STRUT BRACKET			
		1	1	1	6	646.3511	STRUT			
		1	1	1	5	646.3510	STRUT			
2	2		2	4	646.3810	BRACKET				
			1	3	646.2910	DEFLECTOR				
		1	1	2	646.3001	LOWER CUTTER ASSY				
			1	1	646.3301	UPPER CUTTER ASSY				
X					646.4006	LOWER CUTTER TIED				
	X				646.4005	LOWER CUTTER REMOVABLE				
		X			646.4004	FIXED PROVISIONS KIT				
			X		646.4003	CABLE CUTTERS KIT WITHOUT TIED				
				X	646.4002	ASS350 WIPER DEFLECTOR KIT				
					646.4001	ASS350 CABLE CUTTERS KIT				
4006	4005	4004	4003	4002	4001	FIND #	PART #	DESCRIPTION	MATL	SPEC.

QTY	DESCRIPTION	PARTS LIST
NEXT ASSY (S)	ORIGINAL DATE: 08-27-09 DRAWN BY: J. BRAVO CHECKED BY: J. BRAVO DRAWING APPROVAL: J. BRAVO CONTRACT NO.	DART AEROSPACE 3030 ENTERPRISE CT. SUITE A VISTA, CA, 92081 (760)-724-5300
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 1 PLACE DECIMALS: .010 2 PLACE DECIMALS: .005 ANGLES: 1/2°		AS350 CABLE CUTTERS KIT SET: 1046 CODE: 07M16 B: 07M16 SCALE: NONE SHEET: 1 OF 5